






# Work Order ID 52659



October 5, 2009 2:53:28 PM






Page 1

Item ID: D3646-1 *BK* Accept  Setup Start   
Revision ID: B Stop   
Item Name: Arm  
Start Date: 06/10/2009 Start Qty: 8.00  Cust Item ID:  
Required Date: 13/10/2009 Req'd Qty: 8.00  Customer:

## Reference:

Approvals: Process Plan: *BL* Date: *09-10-5* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3646	Rev A								
100	NC BRAKE	0.00							
	Brake NC	0.00							
Brake NC	Memo								
	1-Punch to length as per Dwg D3646 & template DT8958								
									<i>M.H. 09/10/07</i>
110	Small Fab	0.00							
	Small Fab	0.00							
Small Fab	Memo								
	1-Deburr								
									<i>M.H. 09/10/07</i>
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
Quality Control	Memo								
									<i>27 09/10/07</i>

*(8X)*

*(8X)*

*(8X)*

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Item ID: D3646-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Arm

Start Date: 06/10/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M 109091

0.00

09-10-9

(8)

Powder Coating

Memo

START TIME: 8:35

OVEN TEMPERATURE:

328° FINISH TIME:

9:05

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

09/10/09

(8)

Quality Control

150

Identify as per dwg & Stock Location: 229

0.00



Packaging

Memo

0.00

09/10/09 (8)

Packaging

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Item ID: D3646-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Arm

Start Date: 06/10/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13

CMF

09-10-09

# Picklist Print

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Work Order ID: 52659



Parent Item: D3646-1RevA



Parent Item Name: Arm

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	357.6972	16.6737			
304 RD Tube .500 x .035W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

357.6971674

108250

2.23

111704

31.6682737

112187

43.9830937

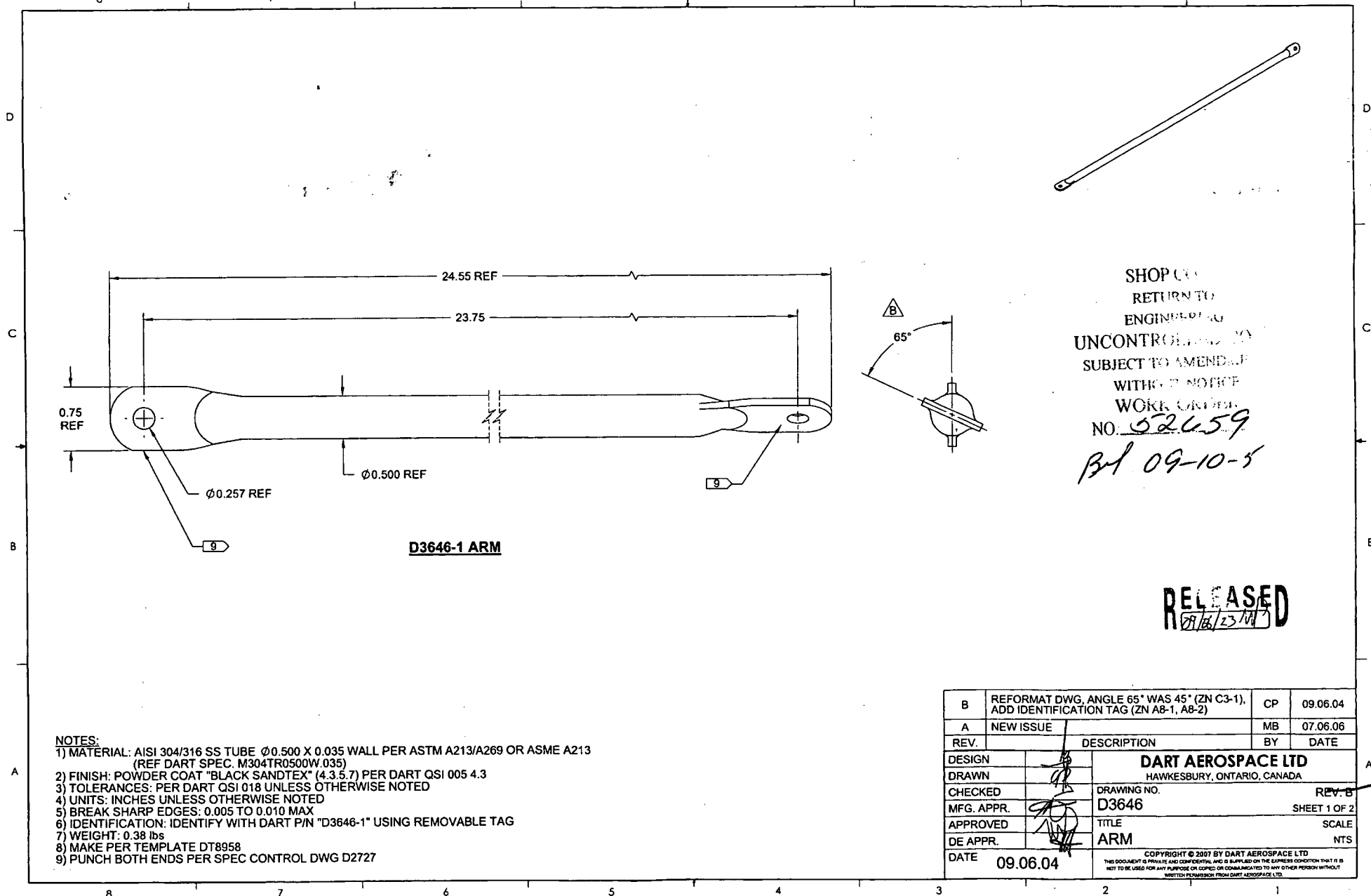
112800 ✓

279.8158

M. H. 09/10/07

M112800

glimece



SHOP CO  
RETURN TO  
ENGINEERING  
UNCONTROLLED BY  
SUBJECT TO AMENDMENT  
WITH NOTICE  
WORK ORDER  
NO. 52659  
Bul 09-10-5

**NOTES:**

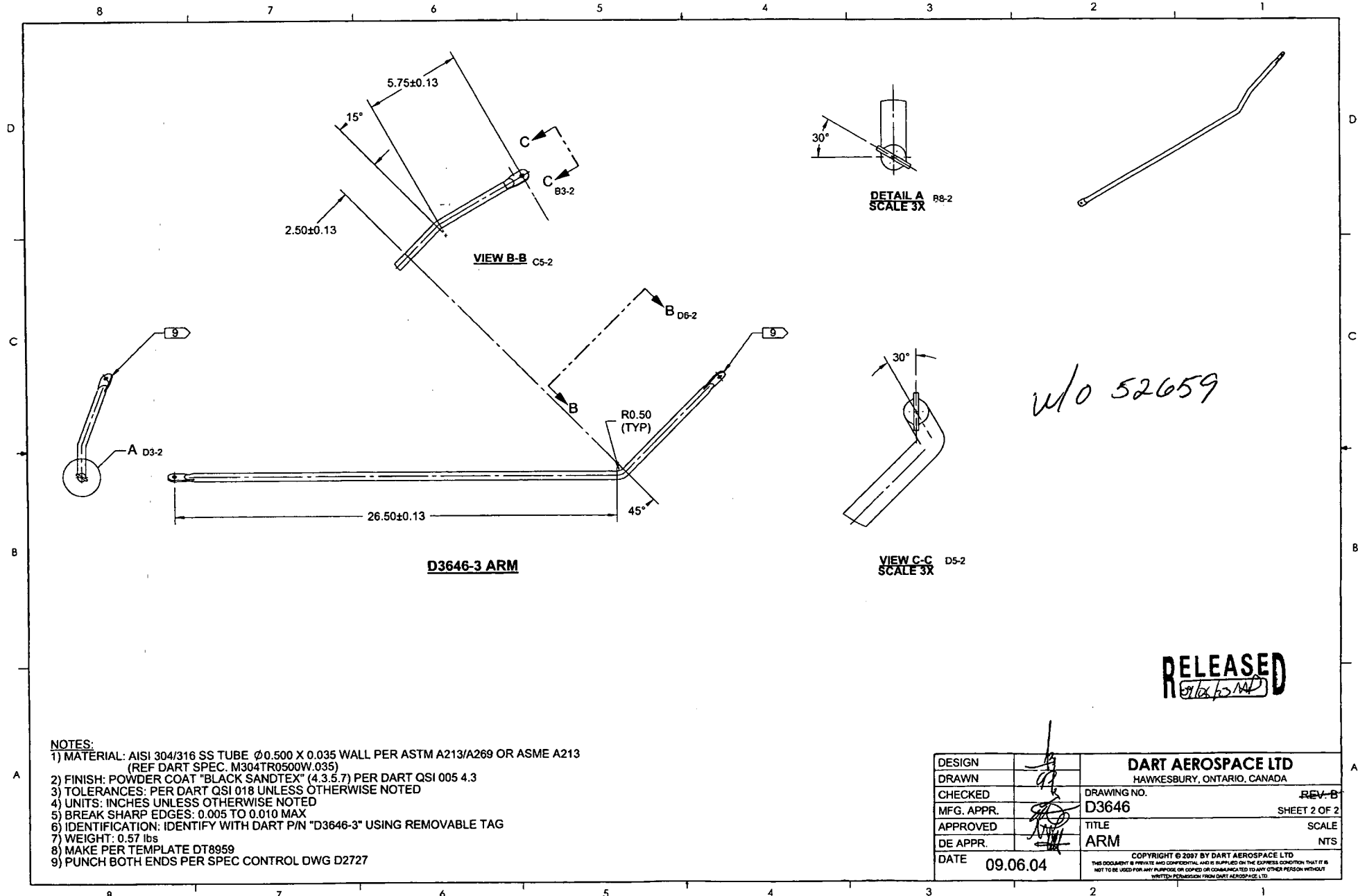
- 1) MATERIAL: AISI 304/316 SS TUBE  $\phi 0.500 \times 0.035$  WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) MAKE PER TEMPLATE DT8958
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.04		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3646  
TITLE ARM  
SCALE NTS  
REV: B  
SHEET 1 OF 2

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RELEASED

W/O 52659